

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002360**Date Inspected:** 15-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 100**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector, M. Paul Stovall, was present at Zhenhua Port Machinery Company,(Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

New Tower Shop, Bay 1

The QA Inspector observed Z. P. M. C. welders Lei Lichao, ID #053619, Li Moughqian, ID #054460, and Li Zhaoqian, ID #048810, weld Skin A to Skin B, the weld number is MUB-MA21-D/J-2A, using Welding Procedure Specification (WPS)-B-T-2232-B-U4b-F. The three (3) welders shared two (2) welding machines. The QA Inspector verified the WPS parameters and recorded the following at different times, 319 amps, 30.4 volts; 317 amps, 30.7 volts; 323 amps, 30.3 volts.

The QA Inspector was asked to check a possible 4 mille-meter (mm) root gap, at the 89-meter Mock-Up. The following measurements were taken at the weld root of joint number MUB-MA21-D/J-5B. The measurements started 460 mm from the end of the weld, slightly off center, 5.2, 5, 4.9, 4, 4.3, and 3.5 mm's. Starting 107 mm's from the end of the joint the measurements were as follows 3.6, 2.8, 2.6, 1.8, and 1.8 mm's.

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Summary of Conversations:

The QA Inspector had no substantial conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
